

Work Order ID 164711

Friday, July 28, 2017 8:34:39 AM

164711

Page 1

Item ID: 646.3717

Revision ID:

Item Name: Doubler

Start Date: 7/18/2017 Start Qty: 6.00

Required Date: 8/3/2017 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: JUL 28 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3700	A

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.15

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.06

C

17/07/28

DAS
40
9-89

C

17/07/28

DAS
40
9-89

Work Order ID 164711

Friday, July 28, 2017 8:34:39 AM

164711

Page 2

Item ID: 646.3717 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 8/3/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12				<u>6</u>			<u>DAS</u> <u>38</u> <u>9-08</u> JUL 28 2017
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG: <u>37419</u> AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	0.00 480.00				<u>6</u>	<u>DAS</u> <u>13</u> <u>9-08</u>	<u>UB</u> <u>20170815</u>	

Work Order ID 164711

Friday, July 28, 2017 8:34:39 AM

164711

Page 3

Item ID: 646.3717 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 8/3/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.12							
Packaging									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.12							
Quality Control									
	1.2 mils thickness primer								
190	Identify as per dwg & Stock Location <u>CCR105</u>	0.00							
190									
Packaging	Memo	0.06							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								

6x SPN 7-8-25

6

AUG 29 2017

DAS 38 9-89

6

AUG 29 2017

DAS 6 9-89

Work Order ID 164711***164711***

Page 4

Friday, July 28, 2017 8:34:40 AM

Item ID: 646.3717 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 8/3/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.60							
Quality Control									

DAS
21
9-89

AUG 29 2017

Picklist Print

Friday, July 28, 2017 8:34:37 AM

Page 1

Work Order ID: 164711

164711

Parent Item: 646.3717

646 3717

Parent Item Name: Doubler

Start Date: 7/18/2017

Required Date: 8/3/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	177.1560	0.036	0.216			
M6061T6S 063									**			17/07/28	DAS
6061-T6 .063 Sheet													40
													9-89

Location

Loc Qty

Loc Code

MAT021

177.156

M134604

36.01

M134830

2.456

M136251

22.4

M136790

9.9

M137041

2.52

M137175

27.3

M137513

61.91

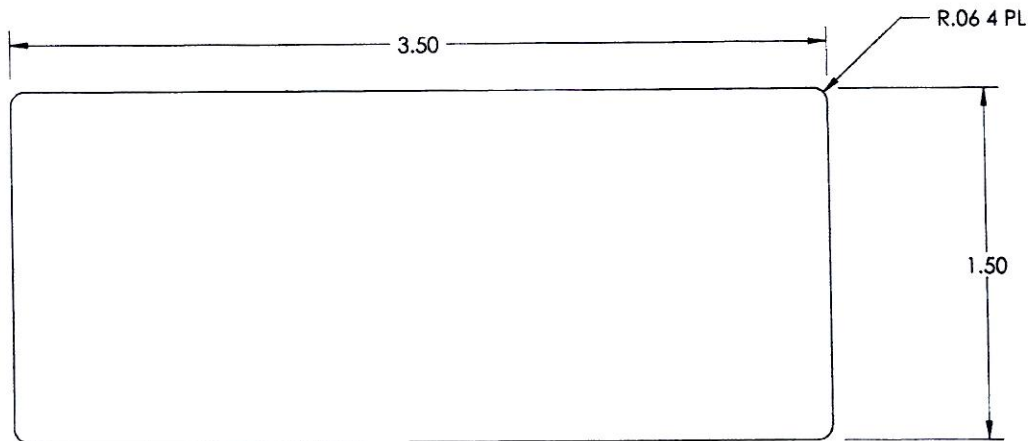
M137599

14.66

0.25

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3717

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164711

JUL 28 2017

NEXT ASSY (S)		ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL	
DRAWN BY P. BRAVO		CHECKED BY J. JOSEPH		
DRAWING APPROVAL P. JOSEPH		DATE 08-18-08		
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ± 3°			SET CHG CODE DTD. NO. REV. B 07M26 646.3700 A	
SCALE: NONE			SHEET 8 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37419**

Purchase Order Date 8/14/2017

PO Print Date 8/21/2017

Page Number 2 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

3	164711	646.3717 Doubler	8/23/2017	6.00	\$6.25	\$37.50
			No			
			8/23/2017			

As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black
As Per MPP-172 Section 4.2
Prime IAW MIL-PRF-23377 TypeI Class N AS PER DWG 646.3700 REV. A

Line Total: \$37.50

4	164729	646.3718 Custom Washer	8/23/2017	10.00	\$3.95	\$39.50
			No			
			8/23/2017			

As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black
As Per MPP-172 Section 4.2
Prime IAW MIL-PRF-23377 TypeI Class N AS PER DWG 646.3700 REV. A

Line Total: \$39.50

5	164660	646.3814 Wiper Bracket	8/23/2017	10.00	\$6.10	\$61.00
			No			
			8/23/2017			

As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black
As Per MPP-172 Section 4.2
Prime IAW MIL-PRF-23377 TypeI Class N AS PER DWG 646.3800 REV. N/C

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

8/21/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913734

Date: 23-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
6 ea	Part: 646.3717 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21580	Rev: A PO: PO37419 Line: 3	DAG 38 9-89 SPN-8-25
10 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21581	Rev: A PO: PO37419 Line: 4	
6 ea	Part: 647.1511 Lower deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 21584	Rev: D PO: PO37419 Line: 7	
12 ea	Part: 649.4813 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21585	Rev: B PO: PO37419 Line: 8	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>23/8/17</u> Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913734

Date: 23-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

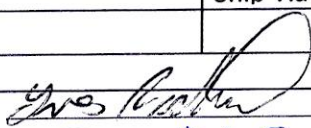
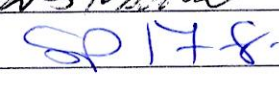
Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
Quantity	Description	
	Certified Signature: 	
	Receiver Signature: 	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	